	r ID 72576										Page 1
Item ID: Revision ID: Item Name: Start Date: Required Date:		Qty: 10.00 Qty: 10.00			Cust Item I			s	etup Star		
	Process Plan:		_ Date: <u>//-08-</u> Date:	Tooling: SPC (Y/N):	Da Da	ate:		R	tun Sta		
Sequence ID/ Work Center ID Draw Nbr	Operat Descrij Revision Nb	otion		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3190	Rev A	:									
100 	t	<b>Memo</b> CUT AS PI DWG REV PROG REV	<u> </u>	0.00					7-17	Ø	
105    <b>                </b> QC	QC2- Ins	spect parts off n Memo	nachine FAI/FAIB	0.00				TB1-	&~1 <b>7</b>		

QC8- Inspect parts - second check

5 Was 118

106

Quality Control

Memo

Quality Control

W/O:	·	*****	· ·	ORK ORDER CHANG	3EQ		<del></del>			<del>,</del>
DATE STEP	PR	OCEDURE CH	W. V. 2/2.	Ву	, D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			NA 44 4					·		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Y	es No	DQA:		_ Date: _	
	Re	solution:	Disposition	on:	QA: N/C	Close	ed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section B				tion	Approval	Approval
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# Work Order ID 72576

Tuesday, August 02, 2011 1:38:58 PM



Page 2

Item ID:

D3190-1

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Chafing Shield

8/2/2011

**Start Qty: 10.00** 

Reg'd Oty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Required Date: 8/8/2011

Date:

SPC (Y/N):

Set Up/

Tool ID

Tool # Plan

Code

Date:

Accept Qty

Reject Reject Qty

Stop

Number

Insp. Stamp

107

Sequence ID/

Work Center ID

Small Fab

Small Fab

**SHEAR** 

Operation

**Description** 

Memo

Memo

Roll as per Dwg D3190

**Run Hours** 0.00

0.00

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

120

Packaging

Identify as per dwg & Stock Location: X

M 11 9 15

Packaging

Memo

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	egory:	NCR: Y	es N	lo <b>DQ</b>	\:	Date:	
	R	esolution:	Dispositi	on:	_ QA: N/0	Clo	sed:		Date: _	
NCR:			VORK ORI	DER NON-CONFORM	ANCE (N	ICR)				
DATE STEP		Description of NC			ion B		Verific	ation	Approval	Approval
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#### Work Order ID 72576

Tuesday, August 02, 2011 1:38:58 PM



Page 3

Item ID:

D3190-1

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Chafing Shield

8/2/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Required Date: 8/8/2011

QC:

Operation

Description

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

**Work Center ID** 

130

Memo

QC21- Final Inspection - Work Order Release

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number Insp.

Stamp

Quality Control

0.00

0.00

MK 11) 11-09-15

W/O:			W	ORK ORDER CHANG	ES			-	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
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NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	tion B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
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### **Picklist Print**

Tuesday, August 02, 2011 1:39:05 PM

Work Order ID: 72576

D3190-1

Parent Item:

Parent Item Name: Chafing Shield



Start Date: 8/2/2011

Required Date: 8/8/2011

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP A□03.05.26□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	•	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 		Purchased	No			100	sf	128.0000	0.2153	2.266316	8, <del>11-8-1</del>	1	
				<b>Location</b>		Loc C	<u>Qty</u>	Loc Code				(20)	
				MAT20			128		_			(2)	
				117	7285		8					$\smile$	

120

118228

W/O:	·		WC	RK ORDER CHANGE	:0			<del> </del>	
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						· ,			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	<b>4</b> :	Date: _	
	R	esolution:	Disposition	n:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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				•					

DART AEROSPACE LTD	Work Order:	72576
Description: Chafing Shield	Part Number:	D3190-1
Inspection Dwg: D3190 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.25	+/-0.030	9.253	>		PROWES2	
3.13	+/-0.030	3,128	7		PROW502 V 130 Z	
0.020	+/-0.010	<b>(د)</b>	>		V	
property -						
						•
		•				
	· · · · · · · · · · · · · · · · · · ·					
						<u> </u>

Measured by:	Audited by:	8	Preliminary Approval:	
Date: \( \( \& - ( \)	Date:	ulo E/18	Date:	

Rev	Date	Change	Revise		Approved
Α	10.04.07	New Issue	KJ '	#Co	AM
				177	

	•									
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·	PAR #:	Fault Categ	ory:	_ NCR: Ye	es N	o <b>DQ</b>	A:	_ Date: _	
	Res	olution:	Disposition		QA: N/C	Clos	ed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section B			Sign & Verification			Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector
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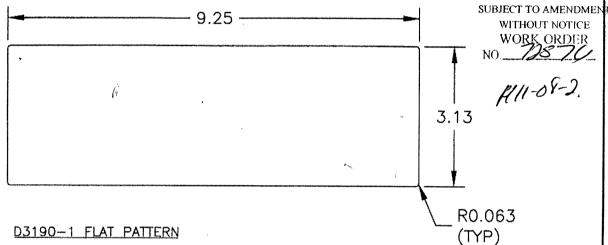


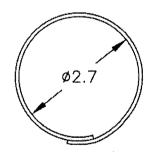


DESIGN #	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED AF	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
 03.05.16		CHAFING SHIELD	1:2
A	03.05.16	NEW ISSUE	

SHOP COPY **RETURN TO ENGINEERING** 

**UNCONTROLLED CO** 





D3190-1 ROLLING DETAIL NOT TO SCALE

#### D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<u> </u>	PAR #:	Fault Category: NCR: Yes No DQA: _					Date:	
	R	esolution:	Disposition	o <u>n:</u>	_ QA: N/C Cld	N/C Closed: Date: _			
NCR:	, .		WORK ORD	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	Section C		QC Inspector
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